Date: Tuesday, 11/11/2008 7:45:54 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: 407 STEP ASSEMBLY
Job Number	: 43298		
Estimate Number	: 11795		
P.O. Number	:	**Part Number**	: D206628033
This Issue	: 11/11/2008 **S.O. No.** :	**Drawing Number**	: N/A
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : LARGE FAB ASSY	**Drawing Revision**	: N/A
Previous Run	: 37015	**Material**	:
Written By	:	**Due Date**	: 21/11/2008 **Qty:** 3 **Um:** Each
Checked & Approved By	:		
Comment	: Est Rev:D As Per Ecn 766 06-01-06 JLM Est Rev:E as per ecn 1118 08-02-05 DD verified by:EC		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

A for JLD 08.11.25

Comment: DOCUMENT CONTROL
Photocopy blue file and type labels as per PPP D206-628-033 ~~CHG 002~~ CHG003

Seq. #:	Machine Or Operation:	Description :
2.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick Packing Kit

Seq. #:	Machine Or Operation:	Description :
3.0	43298A	FLOAT STEP ASSEMBLY LH (206/407)

Comment: Sub-Component 206B STEP ASSY, LH
1 x D2842-041 Batch 43298 — 08/11/28 (x4)

Seq. #:	Machine Or Operation:	Description :
4.0	D2732	Rubber Extrusion

Comment: Qty.: 2.0000 f(s)/Unit Total : 6.0000 f(s)

Qty	Part #	Description	Batch
8	D2732	RUBBER CUSHION	38509

CUT EIGHT PIECES 3.00" LONG — (3) 08/11/28 (x4)

Seq. #:	Machine Or Operation:	Description :
5.0	D27313	Mounting Lug

Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	D2731-3	Mounting Lug	39441 x4 37335 x8

(3) 08/11/28 (x4)

Form: rprocess

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

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Job Number: 43298 **Part Number:** D206628033

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	D28441	Arm

Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2844-1	Arm	37337

(x3) 08/11/28 (x4)

Seq. #:	Machine Or Operation:	Description :
7.0	D28443	Arm

Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2844-3	Arm	39543

(x3) 08/11/28 (x4)

Seq. #:	Machine Or Operation:	Description :
8.0	D3394041	Lug Assembly

Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	D3394-041	LUG ASS,Y	37345

(x3) 08/11/28 (x4)

Seq. #:	Machine Or Operation:	Description :
9.0	AN3C4A	BOLT

Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
3	AN3C4A	Bolt	M110002

(x3) 08/11/28 (x4)

Seq. #:	Machine Or Operation:	Description :
10.0	AN4C14A	Bolt

Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s)
Bolt
batch M107087

(x3) 08/11/28

Seq. #:	Machine Or Operation:	Description :
11.0	AN4C15A	Bolt

Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	AN4C15A	Bolt	M107082

(x3) 08/11/28 (x4)

Form: rprocess

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** _________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/11/2008 7:45:54 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 407 STEP ASSEMBLY

Job Number: 43298
Part Number: D206628033

Job Number:

Seq. #:	Machine Or Operation:	Description :
12.0	AN960C10	WASHER

Comment: Qty.: 3.0000 EACH(s)/Unit Total : 9.0000 EACH(s)
Pick:

Qty	Part Number	Description	Batch
3	AN960C10	WASHER	~~M109174~~ M109165

(x3) SS 08/11/28 (x4)

Seq. #:	Machine Or Operation:	Description :
13.0	AN960C416L	WASHER

Comment: Qty.: 24.0000 Each(s)/Unit Total : 72.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
24	AN960C416L	Washer	M109220

(x3) SS 08/11/28 (x3)

Seq. #:	Machine Or Operation:	Description :
14.0	NAS1515H4L	WASHER

Comment: Qty.: 24.0000 Each(s)/Unit Total : 72.0000 Each(s)
All same Batch
Pick:

Qty	Part Number	Description	Batch
24	NAS1515H4L	Washer	M107008

(x3) SS 08/11/28 (x3)

Seq. #:	Machine Or Operation:	Description :
15.0	MS210434	Nut

Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
12	MS21043-4	Nut (or MS21042-4)	M109166

(x3) SS 08/11/28 (x3)

Seq. #:	Machine Or Operation:	Description :
16.0	NAS1515H3	Washer

Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
3	NAS1515H3	Washer	M107101

(x3) SS 08/11/28 (x3)

Seq. #:	Machine Or Operation:	Description :
17.0	QC4	INSPECT 100% KITS FOR COMPLETENESS

08-12-01 (3)

Comment: INSPECT 100% KITS FOR COMPLETENESS

Kit already inspected c̄ steps verified.

Form: rprocess

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

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Process Sheet

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Drawing Name: 407 STEP ASSEMBLY

Job Number: 43298
Part Number: D206628033

Job Number:

Seq. #:	Machine Or Operation:	Description :
18.0	PACKAGING 1	PACKAGING RESOURCE #1

3X

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D206-628-033
Location: 11
PPP Rev: D

8/12/12 SD

Seq. #:	Machine Or Operation:	Description :
19.0	QC21	FINAL INSPECTION/W/O RELEASE

08/12/02

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

MF 08-01-12

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries